



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-1

Job Sheet 172337



Part No: D3296-1

Job Qty: 6 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/22/18	0.00	0.00	Start Up Waterjet		SC 18/02/17
100	Waterjet	6 pcs		2/22/18	0.03	0.62	Waterjet1		SC 18/02/17
120	QC	6 pcs		2/22/18	0.00	0.00	QC8		38
140	HandFinish	6 pcs		2/23/18	0.00	0.32	HandFinish1		BE B 18-02-21
150	QC	6 pcs		2/23/18	0.00	0.00	QC7-2		38
160	Packaging	6 pcs		2/23/18	0.00	0.00	Packaging3	ST 494	FEB 23 2018
170	QC21-SA	6 Ea		2/23/18	0.00	0.00	QC21		18/02/23

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	3.9576 sf (.6596 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	4	177	0
	5029837	4		

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches ± 0.030	5.110 5.050	5,082	
2	Door Panel	0.060inches ± 0.030	0.090 0.030	0,060	
3	Door Panel	0.300inches ± 0.010	0.310 0.290	0,301	
4	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128	0,129	
5	Door Panel	16.400inches ± 0.005	16.405 16.395	16,400	
6	Door Panel	0.300inches ± 0.010	0.310 0.290	0,302	
7	Door Panel	13.400inches + 0.005 - 0.030	13.405 13.370	13,400	
8	Door Panel	17.000inches ± 0.030	17.030	17,00	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____ QTY Effective : _____ MRB (QS1042) Approval _____

Description Work Order Deviation

Container No: S043496
Part: D3296-1
Job No: 172337
Serial No/Batch: S043496
Revision: D3296
Inspector: _____

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause

Environment ☐	No Re-verification ☐	Pressure/Forced ☐					
Design ☐	Operator ☐	Bending ☐					
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐					
Equip/Tooling ☐	Supplier ☐	Cracks ☐					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐					
Material ☐	Use for Testing ☐	Cuffs ☐					
Internal Transport ☐	Poor Information ☐	Crushing ☐					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐					
Substation ☐	Process Improvement ☐	Marks/Chatter ☐					
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

			16.970	
9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150	14,182
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290	0,302
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053	0,060

Plex 2/15/18 1:02 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

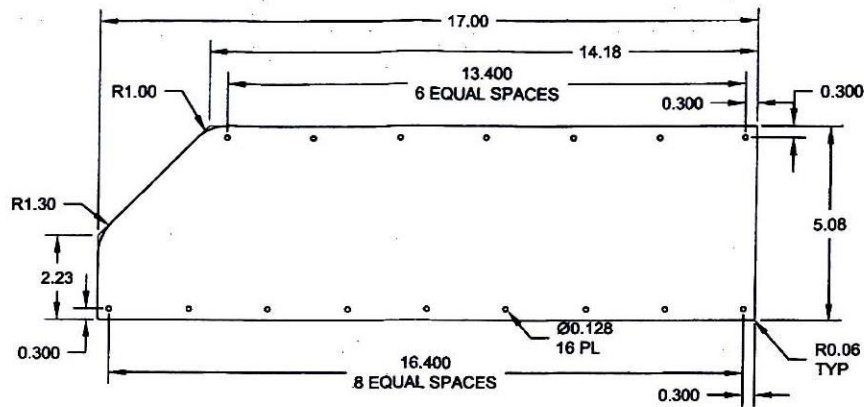


WORK ORDER NON-CONFORMANCE / UPDATE

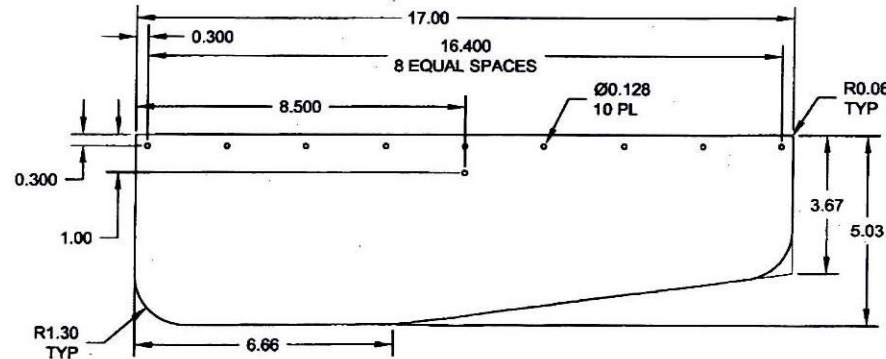
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval							
Description Work Order Deviation			Disposition								
			Completed By								
			Lead hand / Supervisor Approval Verification								
			QC / QA Coordinator Approval								
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:33%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____											



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172337M5
1802-15

RELEASED
2012-11-21
WMO

D3296-1/3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN	99	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3296	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DOOR ASSEMBLY	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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